

Work Order ID 71533

Wednesday, July 06, 2011 11:26:52 AM



Page 1

Item ID: D3907-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 7/6/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 7/13/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

C2

Date: 11/07/09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3907	A								

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per Folio FA823
& Dwg D3907

Dwg Rev: 1/1

Folio Rev: 1/1

Deburr

11/7/7

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/7/7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Wednesday, July 06, 2011 11:26:52 AM

[illegible]

Page 2

[illegible]**Setup Start**[illegible]

Stop

[illegible]**Cust Item ID:**

Customer:

Reference:

Run Start

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

Abstract

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

[illegible]

QC

Memo

0.00

Quality Control

B.A 11/07/07

4

 ϕ

Identify as per dwg & Stock Location: WA

0.00

[illegible]

Packaging

Memo

0.00

Packaging

*****STOCK IN BASKET CELL*****

11/7/8 (41) SP

QC21- Final Inspection - Work Order Release

0.00

[illegible]

QC

Memo

0.00

Quality Control

mf 11-07-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 11:26:50 AM

Page 1

Work Order ID: 71533

Parent Item: D3907-1

Parent Item Name: Bushing



Start Date: 7/6/2011

Required Date: 7/13/2011

Start Qty: 40.00

Required Qty: 40.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304R0.375

Purchased

No

100

f

15.7600

0.03

1.2



304 ROUND BAR 0.375



SA

11/7/7

Location

MAT029

117130

Loc Qty

15.76

15.76

Loc Code

1.3/21

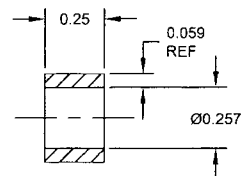
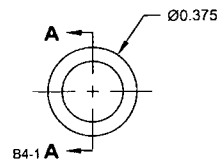
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3907-1 BUSHING

SECTION A-A C5-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71533
CZ11/07/06

RELEASED
9/10/11

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

OR: AISI 304/316 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

A	NEW ISSUE	AJS	09.03.11
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3907	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BUSHING (BASKET REPAIR)	NTS
DATE	09.03.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>"THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD."</small>	